

Patent claims

1. Process for producing (cigarette) packs from blanks which are severed from a continuous material web made of thin packaging material, such as paper, and folded, folding tabs being connected to one another by adhesive bonding, **characterized by the following** 5 **features:**

- a) the material web is provided on both sides, in accordance with the folding tabs which are to be connected to one another, with regions of glue, that is to say they are provided with areas of glue (34..39; 48..51) or with spots of glue,
- b) the regions of glue consist of a (cold) glue, which only in conjunction with a corresponding (mating) area of glue produces the adhesion necessary for connecting the folding tabs, but which does not adhere directly to the material web.
- c) the regions of glue are positioned such that, in the wound state of the material web, regions of glue on one side of the said material web do not overlap with regions of glue on the other side of the material web.

2. Process according to Claim 1, **characterized in that** at least the regions of glue and/or the material web are provided with a coating which reduces the adhesive action of the glue directly on the material web.

3. Process according to Claim 1 or 2, **characterized in that** the regions of glue arranged on one side of the material web are offset in the transverse direction in relation to the regions 20 of glue arranged on the other side of the material web, that is to say they are positioned in mutually offset lines or planes.

4. Process according to Claim 1 or one of the further claims, **characterized in that** the non-folded material web, provided with regions of glue on both sides, is drawn off from a reel, and then folded continuously in the longitudinal direction, in particular with a Z-fold 25 (23) and/or a double-layered base strip (29) being formed in the process, the transverse folding of the material web resulting in offset regions of glue which are assigned to one another being positioned relative to one another such that, when folded, the subsequently severed blanks have regions of glue for folding tabs overlapping.

5. Process according to Claim 1 or one of the further claims, **characterized in that** 30 separate blanks, in particular a revenue stamp (42), are connected to the pack by corresponding regions of glue, in particular by regions of glue arranged in the region of the

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A1* front wall (10), rear wall (11) and end wall (16), on the one hand, and corresponding regions of glue on the inside of the revenue stamp (42), on the other hand.